

Work Order ID 158103

Thursday, March 09, 2017 2:18:41 PM

158103

Page 1

Item ID: D3969-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Spring (Basket Lid)

Start Date: 3/13/2017 Start Qty: 10.00

10

Cust Item ID:

Required Date: 3/27/2017 Req'd Qty: 10.00

10

Customer:

Reference: SCHEDULED

Run Start

NR1

Approvals: Process Plan:

Date: MAR 10 2017 Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3969

D

0.00

100

100

Purchasing

Purchasing

Memo

Issue P/O:

35573

Order as per Dwg D3969

Possible supplier: LS Technologies

part#: SSA4/8-122-310-360N

Material release note is required

0.00

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Packaging

Memo

***Measure compression only at
5mm on gas spring***

0.03

10 x 8017-03-21DAS
21
9-89DAS
13
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
☐ OTHER : _____					

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Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Quality Control

Memo

***Measure compression only at
5mm on gas spring***

0.03

MAR 27 2017

10

17-03-24

122

0.00

122

Small Fab

Small Fab

Memo

CRIMP END FITTING AT LOCATION SHOWN ON DWG (SEE NOTE 8)

0.13

IF NOT MADE BY VENDOR

MAR 27 2017

124

QC5- Inspect part completeness to step on W/O

0.00

124

QC

Quality Control

Memo

0.03

10

17-03-24

DQA: _____ Date: _____



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Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: St364

0.00

130

Packaging

Memo

0.02

Packaging

(1)

MAR 27 2017

DAS
6
9-89

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.17

Quality Control

17/3/27  MAR 27 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Misidentified ☐	Past Due ☐																																																																

Thursday, March 09, 2017 2:18:46 PM



158103

D3969-3

Required Date: 3/27/2017

Required Qty: 10.00

IPP Rev:B as

[illegible]

DQA: _____ Date: _____



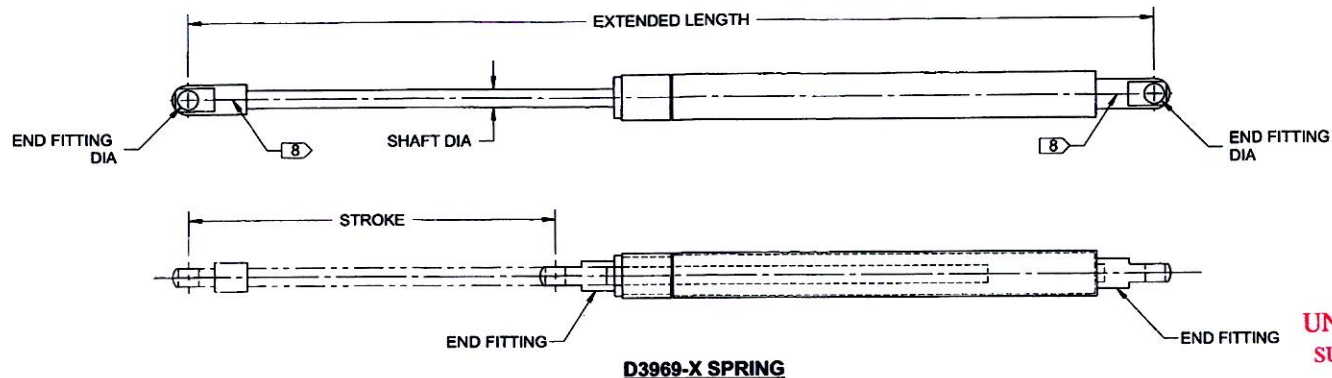
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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OTHER : _____					

SPECIFICATION CONTROL DRAWING



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 158103 MLJ
1703-10

DART PART NUMBER	STROKE (mm/in)	EXTENDED LENGTH (mm/in)	SHAFT DIA (mm/in)	FORCE (N/lbs)	END FITTING TYPE	END FITTING DIA (in)	CASING MATERIAL	PREFERRED SUPPLIER	SUPPLIER PART NUMBER	WEIGHT APPROX
D3969-1	122/4.80	315/12.40	6/0.24	310/69.7	BLADE	0.257	STAINLESS STEEL	LS TECHNOLOGIES	SSA4/6-122-315-310N	0.27 lbs
D3969-3	122/4.80	315/12.40	8/0.31	360/80.9	BLADE	0.257	STAINLESS STEEL	LS TECHNOLOGIES	SSA4/8-122-310-360N	0.32 lbs
D3969-5	122/4.80	315/12.40	6/0.24	133/29.7	BLADE	0.257	STAINLESS STEEL	LS TECHNOLOGIES	SSA4/6-122-315-133N	0.27 lbs
D3969-7	122/4.80	315/12.40	6/0.24	222/50.0	BLADE	0.257	STAINLESS STEEL	LS TECHNOLOGIES	SSA4/6-122-315-225N	0.27 lbs
D3969-9	130/5.12	343/13.50	8/0.31	360/80.9	BLADE	0.257	STAINLESS STEEL	LS TECHNOLOGIES	SSA4/8-130-343-360N	0.35 lbs

NOTES:

- 1) MATERIAL: SEE CHART
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3969-X" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: SEE CHART
- 8) CRIMP END FITTING AT APPROXIMATE LOCATION SHOWN, PER MANUFACTURERS REQUIREMENTS

RELEASED
2016-05-19
16-58

APPROVED

D	ADDED -7/-9	ML	16.05.12
C	REDRAWN IN SW. ADDED -3 & -5; ADDED SHAFT DIA COLUMN TO CHART. FORCE FOR -1 CORRECTED (WAS 60.0 lbs)	JPH	10.03.04
B	DRAWING RENAMED WAS: GAS SPRING (BASKET LID). NOTE 8 ADDED.	AJS	09.11.10
A	NEW ISSUE	AJS	09.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	AS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ML		
CHECKED	AJS	DRAWING NO.	REV. D
MFG. APPR.	DD	D3969	SHEET 1 OF 1
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	BASKET LID SPRING	NTS
DATE	16.05.12	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO35573**

Purchase Order Date 3/13/2017

PO Print Date 3/13/2017

Page Number 1 of 2

Order From :
LS TECHNOLOGIES INC.
314 JESSOP AVE
SASKATOON, SK S7N 1Y6
CA

VC-LST0001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

MAR 13 2017

Contact Name
Vendor Phone 306 683 5000

Ship To Contact
Ship To Phone
Ship Via: FedEx Overnight collect
Ship Acct:

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB EXW - (Ex Works)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	SSA4/8-122-310-360N AS PER DWG D3969-3 REV. D B158103	Gas Spring	3/17/2017 Yes 3/17/2017		10.00 Each	\$65.00	\$650.00
Line Total:							\$650.00
2	B8-240-575-150N AS PER DWG D3552-11 REV. L B158106	GAS SPRING	3/17/2017 Yes 3/17/2017		8.00 Each	\$41.36	\$330.91
Line Total:							\$330.91

PO Instructions: Fedex Acc#151793240

Note:

3/13/2017

LS Technologies Inc
314 Jessop Ave
Saskatoon, SK S7N 1Y6

Ph: 306-683-5000 Fax: 306-683-6403

Packing Slip

P.O. No.	Date	Invoice #
35573	3/20/2017	16252

Bill to:
Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7

Ship to:
Main Finished Goods Location Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7

Ship	Via	FOB
3/20/2017	Fed-Ex	

Qty	Description
10	D3969-3 B158103 Stainless Gas Spring (SSA4/8-122-310-360N) LABELLED WITH PERMANT INK MARKER ONLY - NO LABELS
8	D3552-11 B 158106 Gas Spring
Shipping Via FED EX Tracking # 778693021097	
SP17-03-21	

Order checked by :





LS Technologies Inc
314 Jessop Ave
Saskatoon, SK, S7N 1Y6
Ph: (306) 683-5000 Fax: (306) 683-6403

Certificate of Conformance

March 20, 2017

This is to certify that the parts listed below meets specifications as required by your order.

10 Units : D3969-3 B158103 Stainless Gas Spring (SSA4/8-122-310-360N)

8 Units : D3552-11 B158106 Gas Spring (B8-240-575-150N)

Country of Manufacture : Canada
Date of Manufacture : March 2017
This product is ROHS compliant.

Purchase Order # 35573
Inv# 16252

L S Technologies Inc Canada

A handwritten signature in black ink, appearing to be 'Nolan Fehr', written over a horizontal line.

Nolan Fehr
President